

Work Order ID 62797



Page 1

October 13, 2010 1:30:21 PM

Item ID: D4074-3

Accept



Setup

Start



Revision ID:

Item Name: Channel

Stop



Start Date: 10/08/10 Start Qty: 1.00



Cust Item ID:

Required Date: 10/15/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run

Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4074	A

100



Waterjet

FLOW CNC Waterjet

304 .050

Memo

1-Cut as per Dwg

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

110



QC

Quality Control

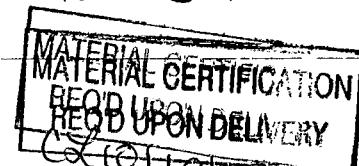
QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

10/10-13



10/10-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

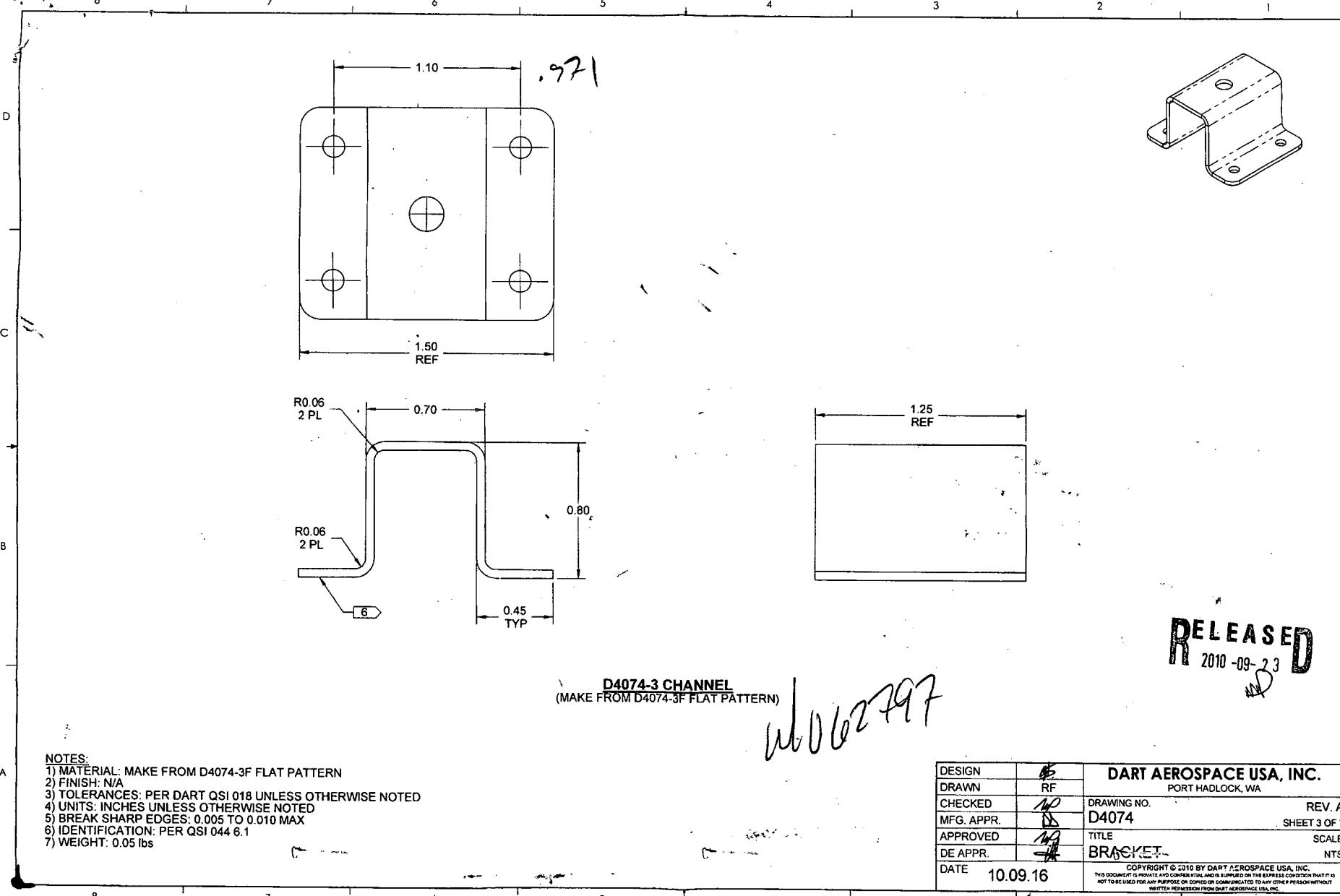
DART AEROSPACE LTD	Work Order:	62797
Description: CHANNEL	Part Number:	D4074-3
Inspection Dwg: D4074-3 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

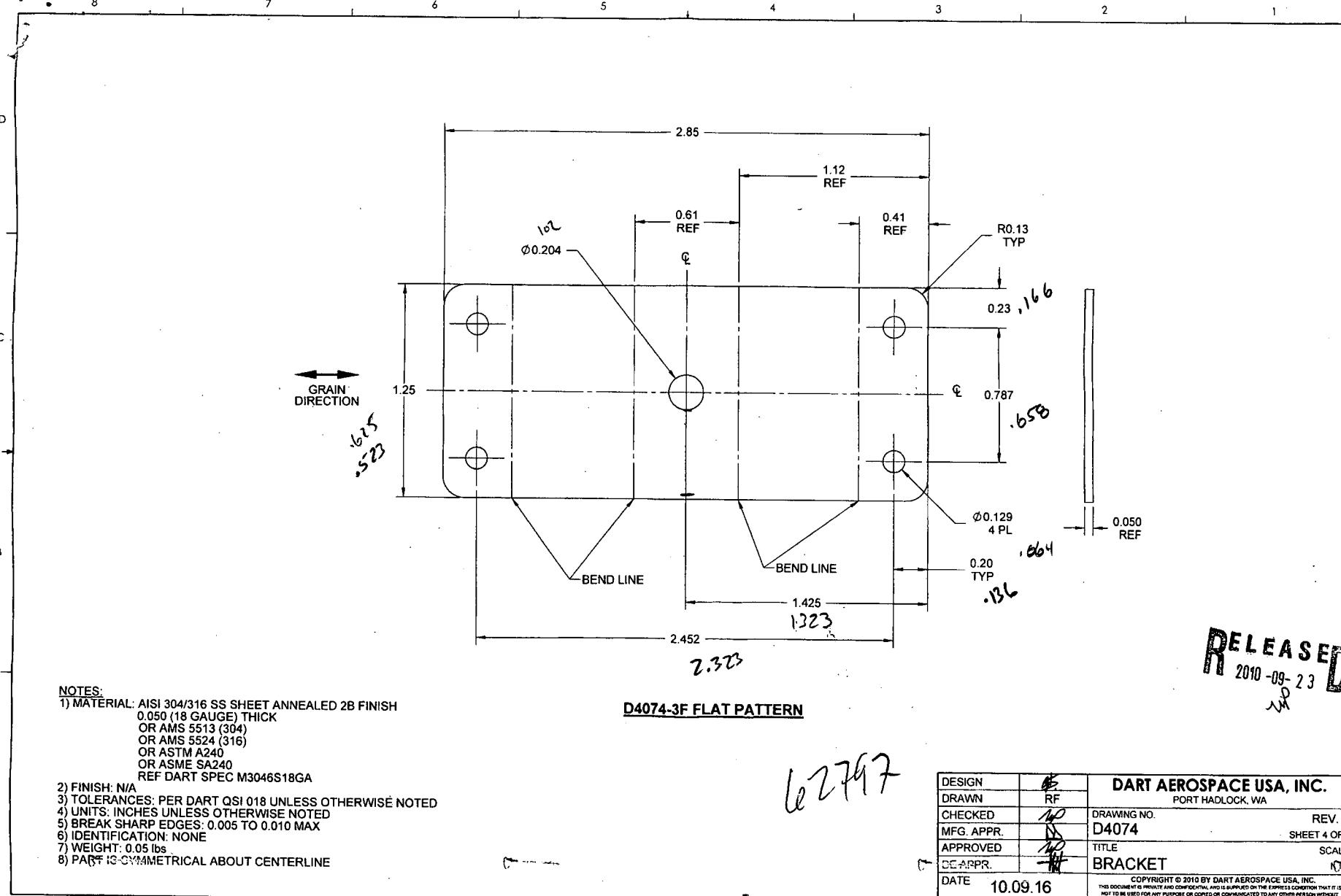
Measured by: <u>BS</u>	Audited by: <u>S</u>	Prototype Approval: <u>N/A</u>
Date: <u>10-10-13</u>	Date: <u>10/10/14</u>	Date: <u>N/A</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



DESIGN	65	DART AEROSPACE USA, INC.
DRAWN	RF	PORT HADLOCK, WA
CHECKED	100	DRAWING NO.
MFG. APPR.	100	REV. A
APPROVED	100	D4074
DE APPR.	100	SHEET 3 OF 7
DATE	10.09.16	TITLE
		SCALE
		NTS

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62747

DESIGN	6	DART AEROSPACE USA, INC.
DRAWN	RF	PORT HADLOCK, WA
CHECKED	10	DRAWING NO.
MFG. APPR.	10	REV. A
APPROVED	10	D4074
QC APPR.	10	SHEET 4 OF 7
DATE	10.09.16	TITLE
		SCALE
		175
		BRACKET

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Receiving Report

Date: 9/7/9

Batch No: 1112178

Supplier: MAGNA

Dart P/O: 10030

Packing Slip: Yes No
Invoice: Yes No
Receipt: Cash Cr

Release Note Attached: Yes No N/A
Waybill Attached: Yes No N/A
Shipment Complete: Yes No N/A
QC Inspection N/A
Work Order N/A

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments
16202		20	0	0	20	

Initials of receiver (if shipment OK) Level 12

Production/Admin:

Date

Received/Costing

Initial

Location

Purchase Order Receipt Listing

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July 13, 2009 8:15:50 AM

All amounts are calculated in domestic currency.

All Vendors PO ID PO10030 All Receipt Dates All Line Item Types
All Item ID/GL/WOs All Rec. Employees All Currencies
Grouped by Reference (Item, WO, GL)

Purchase Order ID	Line Nbr/ Insp Req	Project ID	Vendor ID/ Name/ Currency Type	PO U/M / Stock U/M	Req Date	Req Qty	Recv Date/ Recv Emp	Recv Qty	Cost Per Unit/ Recv Value	Inspected Qty/ Rejected Qty	MRB Qty/ MRB Reject Qty	Book Amt	
Reference: \Description													
PO10030	1	VC-MAG002	sf	M304S18GA	304/316 .050 Sheet	7/08/09	160.0000	7/13/09	160.0000	\$5.00	0.0000	0	\$800.00
	No	Magna Stainless CAD	sf					LAV001		\$800.00	0.0000	0	
										Total Received Quantity:		160.0000	
										Total Quantity to Inspect (PO U/M):		0.0000	
										Total Reject Quantity:		0.0000	
										Total Receipt Value:		\$800.00	
										Total Balance Due Quantity:		0.0000	

Magna Stainless

5775 Kieran St, Saint-Laurent, Quebec H4S 0A3
 Phone: (514) 339-1211 Watts: 1-800-363-6646 Fax: (514) 339-1105

PACKING LIST

I014049

Page: 1 of 1

SOLD TO:
 DART AEROSPACE LTD
 1270 ABERDEEN STREET

SHIP TO:
 DART AEROSPACE LTD
 1270 ABERDEEN STREET

HAWKESBURY , ON
 K6A 1K7
 Contact: CHANTAL

HAWKESBURY , ON
 K6A 1K7
 Ship Terms: PREPAID

MTR: Y

SPECIAL INSTRUCTIONS

STOCK

Currency	Sales Person	Customer Phone	Customer Fax	Customer PO	
CANADIAN DOLLARS	ERYCK BLAIS	(613) 632-5200	(613) 632-1053	P010030	
Sales Order	Terms	Ship Via	Date Ordered	Date Required	Date Shipped
W015510	NET 30 DAYS ✓	NIR:R-557065-1	07/08/09	07/09/09	07/09/09

Ordered	Back Ordered	Unit	Description	Bundle #	Heat #	Shipped
5 ✓ <i>Aug 7/09</i>		PC	STAINLESS SHEET SSH 304 2B 18ga x 48" x 96"	335 LB / 5 PC	L028387	SC17938
Skids: 1				Total	Weight:	35 LB

Received by: _____

Date: _____ Sgn: _____



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PO REPRINT

Purchase Order ID PO10030

Purchase Order Date 7/08/09
PO Print Date 7/08/09

Page Number 1 of 1

Order From :

MAGNA STAINLESS
5775 RUE KIERAN
ST LAURENT, QC H4S 0A3
CA

VC-MAG002

FAXED
6/9/09

Contact Name

Vendor Phone 800 363 6646
Vendor Fax 514 339 1105
Vendor Account Nbr

Buyer

Requisition Nbr
Tax Resale Nbr 6122-5207
Terms Net 30
Currency CAD
FOB

Ship To : DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req. Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	M304S18GA	304/316 .050 Sheet	7/08/09 Yes	✓ 160.00 sf	Yours ppd	\$5.0000 <i>149.19</i>	\$800.00
2	D6202P A	I Beam Extrusion	7/08/09 Yes	20.00 f	Yours ppd	\$34.7500	\$695.00

Special Inst: MATERIAL: AISI 304/316 SHEET
ANNEALED 2B FINISH
AS PER MIL-S-5059 OR AMS
5513/5524 OR ASTM A240
OR ASME SA240

Special Inst: DESCRIPTION AMERICAN
STANDARD I-BEAM
SIZE: 4.000" X 1.796" X 0.326" THICK
MATERIAL: 6061-T6 / T651 AS PER
QQ-A-200/8
MINIMUM ULTIMATE TENSILE
STRENGHT = 38 KSI
MINIMUM YIELD TENSILE
STRENGHT = 35 KSI

PO Total: \$1,495.00

**MATERIAL CERTIFICATION
REQ'D UPON DELIVERY**

CL *W*
No substitution or deviation w/out
consent.
Certificate of Conformity or Material
Certification required when applicable

Change Nbr: 2

Change Date: 7/08/09

POSCO Mill Test Certificate/검사증명서 M0 13117

Order No./계약번호: 0003353485

Supplier/주문자: DAE WOO INTERNATIONAL CORP.

Customer/구매자: MAGNA STAINLESS INC.

Certificate No./증명서번호: 080910-PRSE-010-001

Date of Issue/발행일자: Sep., 16, 2008

Surface Finish/표면마무리: NO.2B

PO No./주문번호: 1353485

Commodity/품목: STAINLESS COLD ROLLED COIL

Spec & Type/규격: ASTM-A240-304

Size/자수 재료번호	Product No. 제작번호	Qula- tity 수량	Weight (kg)	Heat No. 제작번호	P. S. T. O. N.	Tensile@Changseon MPa (kgf/cm ²)	TS (kgf/cm ²)	EL (%)	Hard- ness HRC	Chemical Composition/화학성분(%)	C Si Mn P S Cr Ni Cu Mo N									
0.90x1219xC	QEH0799A	1	4,677	SE37926	T	266	643	80	82.0		0.09	0.52	1.055	0.283	0.56	1616	0.004	442	23	381
0.90x1219xC	QEH0799B	1	4,677	SE37926	B	277	649	80	83.5		0.09	0.52	1055	0.293	0.59	1816	0.004	442	23	381
*** Sub. Total. (110) ***		2				277	649	80	83.5											
1.20x1219xC	QEH0031B	1	5,649	SC17938	T	261	651	80	82.3											
1.20x1219xC	QEH0031C	1	4,180	SC17938	B	288	663	59	84.7											
1.20x1219xC	QEH0031D	1	6,546	SC17938	T	261	651	80	82.3											
*** Sub. Total. (020) ***		3				288	663	59	84.7											
1.50x1219xC	QEH0030A	1	5,369	SC1797	T	285	643	58	83.7											
1.50x1219xC	QEH0030B	1	5,379	SC1797	B	287	646	56	83.0											
1.50x1219xC	QEH0030C	1	5,225	SC1797	T	285	643	58	83.7											
*** Sub. Total. (030) ***		3				287	646	56	83.0											
						288	663	59	84.7											
						16,636 (kg)														
						15,973 (kg)														

Position: T: Top, M: Middle, B: Bottom

Tensile Test: Direction: Transversal, Gauge Length: 50mm (Rectangular)

YP Method: 0.2% off-set

Drop Test: L: Ladle Analysis

Chemical Composition Unit: 2x1/100, 3x1/10000, 4x1/100000, 5x1/100000

Tr: It is within the standard range (<0.006%) and include trace element

We hereby certify that the material herein has been made in accordance with the order and specification.

Test Certificate is issued according to EN10204-3.4B.
This Mill Test Certificate cannot be copied for any purpose.

Surveyor To:

POSCO Pohang Works, 5 Dongchon-dong, Nam-gu, Pohang-si, Gyeongsangbuk-do, 790-785, Korea

Chief of material testing section
Jo, Won (

W.G. Jo

RUSH

18

NOTE SHEET



Project# : 00267

Part# : D3849-047

Description : Wearplate ass'y

If item not required write N/A in "responsible" column

Item	Action required	Responsible	Due Date	Done by / Date
1	M304S18GA 0.050" thick. Batch: _____ Cut D3849-7 as per dwg	X 128 SF magna		
2	M-NEO60-S.063 black neo 0.063" batch: _____ Cut D3848-7 as per dwg			
3	M304B0.500X2500 SS bar Batch: _____ Cut D3901-1 as per dwg			
4	Bend wearplate as per dwg			
5	Weld as per dwg D3849			
6	QC 9 / QC 5			
7	Powdercoat gray sandtex per QSI 005			
8	QC 3			
9	Bond gasket as per dwg			
10	QC 5			
11	Identify and Stock			
12				
13				